

### **Amendments to the claims**

1. (Currently Amended) An aluminum alloy billet as cast for forging, obtained by a continuous casting process, the alloy comprising: 0.005 to 0.015 wt% of Ca, a surface of which roughness is not more than Ra 17 35, and a segregation layer having 0.2 to 2 mm thickness and generated in the surface.

2. Canceled.

3. (Currently Amended) An aluminum alloy billet as cast for forging, obtained by a continuous casting process, the alloy comprising: according to claim 1, wherein Be is added in a range from 0.0005 to 0.020 wt % of Be, a surface of which roughness is not more than Ra 17, and a segregation layer having 0.2 to 2 mm thickness and generated in the surface.

4. (Withdrawn) A continuous casting process for an aluminum alloy billet as cast in accordance with claim 1 for forging, the process comprising: charging a melted metal consisting of the aluminum alloy material into a mold at a predetermined casting rate, the mold having a discharge edge through which the solidified aluminum alloy material is discharged; and controlling the casting rate such that a solidification interface of the aluminum alloy material is positioned inside the mold away from the discharge edge.

5. (New) A continuous casting process for an aluminum alloy billet as cast in accordance with claim 3 for forging, the process comprising: charging a melted metal consisting of the aluminum alloy material into a mold at a predetermined casting rate, the mold having a discharge edge through which the solidified aluminum alloy material is discharged; and controlling the casting rate such that a solidification interface of the aluminum alloy material is positioned inside the mold away from the discharge edge.